

Date: Thursday, 11/09/2008 10:41:59 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SADDLE, OUTBOARD, RH, 206
Job Number :	41975		
Estimate Number :	10523		
P.O. Number :		Part Number :	D26652
This Issue :	11/09/2008	Drawing Number :	D2665 REV. D
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	//	Drawing Revision :	D
Previous Run :	38750	Material :	
Written By :		Due Date :	10/10/2008
Checked & Approved By :	1008.9.11		
Comment :	Est: C 00.11.01 Removed P/O for Powder Coat - in house process EC Est Rev:D As per Rev D 07-03-19 JLM		

Qty: 10 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	Saddle Billet, 7075
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
 7075-T7351 2X6.25X7.875
 Cut Size 2.0" x 6.25" x 7.88" Grain Along Long 7.88 Length

B 33792 X 10

SF 08/09/25

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 1- Program batch number
 2- Machine Step # 1 of Folio and visually inspect as per attached Dimension Sheet
 3- Machine Step # 2 of Folio and visually inspect as per attached Dimension Sheet
 4- Machine Step # 3 of Folio and visually inspect as per attached Dimension Sheet
 5- Deburr

PTO →
 SF 08/09/25

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine Keyway and inspect per attached dimension sheet

SF 08/09/26

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SF 08/09/26

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

mk SF 08/09/27

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D2665-2 PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: D Date: 08/09/30
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 41975		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/09/26	2.0	First part run at zero and figure that the flange thickness was too thick. I lower the tools but forgot to lift all the other tools so the dimension of .110(L) $\pm .010$ was .127.	CP 08.09.26 PC 08/04/2	DEPTH OF CUT IS 0.127". So thickness IS 0.108" MIN, 0. PART ACCEPTABLE.	08/09/26	08/09/30	08.09.26 PC 08/04/2	08/09/30
		R.C operator error						

NOTE: Date & initial all entries

Date: Thursday, 11/09/2008 10:41:59 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, RH, 206

Job Number: 41975

Part Number: D26652

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 08/09/29

(B)

7.0

POWDER COATING

POWDER COATING



M109152



(10X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:50
320°F
9:20

M-L 08/09/29

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-09-29

(X10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

R 8/29

(10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/30

Job Completion



MF 08-09-30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 41975
Description: 206 Saddle, Outboard, Right side	Part Number: D2665-2
Inspection Dwg: D2665 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.112	.113	.113	.113		
B	0.100	0.140		.120	.127	.121	.121		
C	1.125	1.145		1.133	1.133	1.133	1.133		
D	0.615	0.685		.677	.677	.677	.677		
E	0.240	0.260		.254	.254	.253	.253		
F	1.313	1.343		1.323	1.325	1.325	1.325		
G	0.210	0.230		.220	.222	.222	.221		
H	0.100	0.180		.140	.140	.140	.140		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.573	1.573	1.573	1.573		
K	0.235	0.240		.239	.239	.239	.239		
L	0.100	0.120		.127	.127	.118	.111		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		.510	.510	.510	.510		
O	5.990	6.010		6.003	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.318	.318	.318	.318		
S	0.315	0.322		.315	.320	.320	.320		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.800	.800	.800	.800		
W	0.540	0.560		.550	.550	.550	.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.921	.921	.921	.921		
AA	0.490	0.510		.500	.495	.497	.497		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>JS</i>	Audited by: <i>AK</i>
Date: 08/09/25	Date: 08/09/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order: 41915
Description: 206 Saddle, Outboard, Right side	Part Number: D2665-2
Inspection Dwg: D2665 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

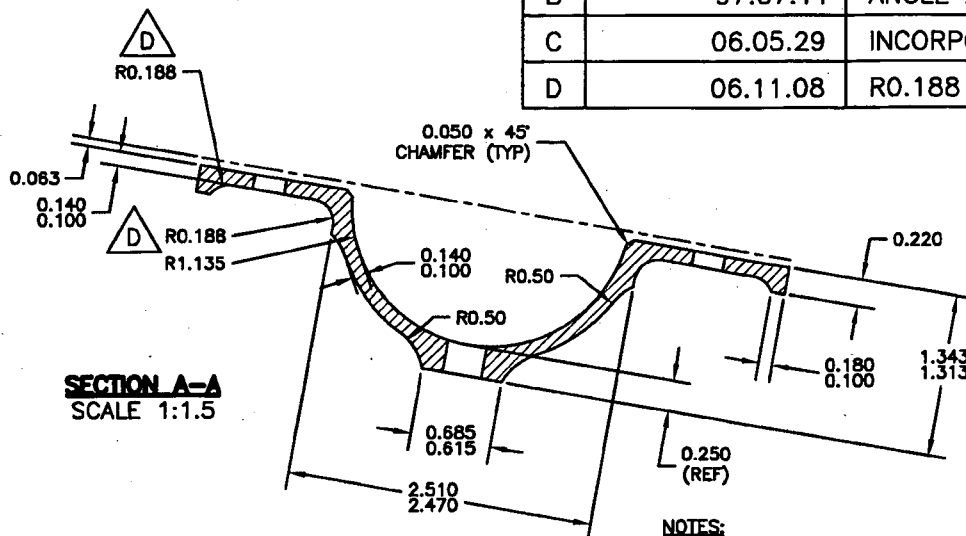
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				54	62	72	64		
A	0.100	0.140		.113	.113	.113	.112	.113	.113
B	0.100	0.140		.120	.120	.120	.126	.124	.125
C	1.125	1.145		1.135	1.135	1.135	1.135	1.135	1.135
D	0.615	0.685		.670	.670	.670	.676	.675	.673
E	0.240	0.260		.252	.252	.252	.251	.251	.251
F	1.313	1.343		1.325	1.325	1.325	1.325	1.325	1.326
G	0.210	0.230		.220	.222	.222	.221	.222	.221
H	0.100	0.180		.140	.140	.140	.140	.140	.140
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	2.496
J	1.565	1.585		1.575	1.575	1.575	1.572	1.572	1.573
K	0.235	0.240		.239	.239	.239	.238	.238	.237
L	0.100	0.120		.112	.112	.112	.110	.110	.110
M	0.990	1.010		1.000	1.000	1.000	1.000	1.000	1.000
N	0.510	0.515		.510	.510	.510	.512	.511	.512
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000	6.000
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	1.250
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
R	0.313	0.318		.318	.318	.318	.318	.318	.318
S	0.315	0.322		.320	.320	.320	.320	.320	.320
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
U	1.357	1.367		1.360	1.360	1.360	1.361	1.360	1.366
V	0.787	0.807		.800	.800	.800	.796	.796	.796
W	0.540	0.560		.550	.550	.550	.545	.546	.545
X	1.674	1.684		1.679	1.678	1.678	1.678	1.679	1.679
Y	0.257	0.262		.258	.258	.258	.259	.259	.259
Z	0.912	0.932		.921	.921	.921	.925	.925	.925
AA	0.490	0.510		.500	.500	.500	.502	.501	.503
AB	0.178	0.198		.188	.188	.188	.188	.188	.188
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>
Date: 08/09/20	Date: 08/09/22

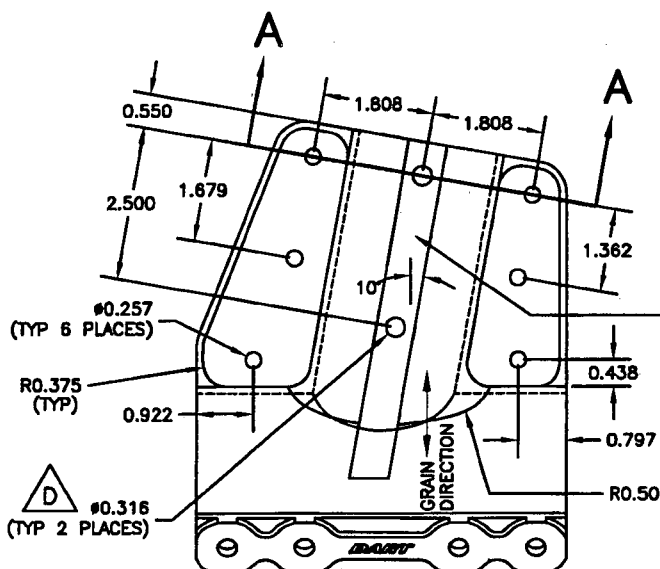
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
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DART

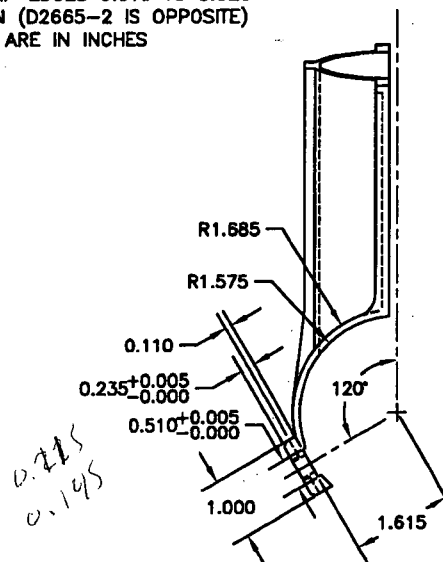
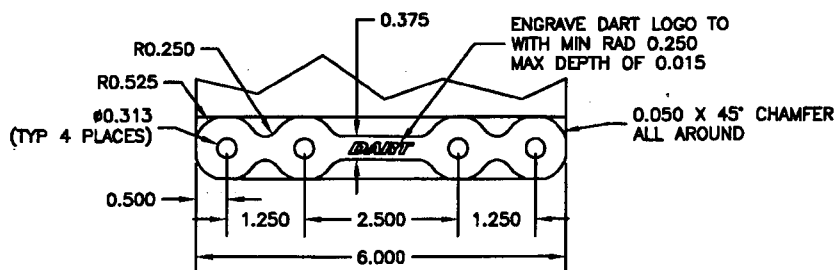
DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2665	REV. D SHEET 1 OF 1
DATE 06.11.08		TITLE SADDLE FWD OUTSIDE HIGH	SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010



SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY

D2665-1 SADDLE FWD OUTSIDE HIGH

WITHOUT NOTICE
WORK ORDER

NO. 41975

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